

Work Order ID 84893

May-29-12 2:47:35 PM

84893

Page 1

Item ID: D209-669-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Replacement Skidtube

Stop

NS2

Start Date: 29/05/2012 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/29

Tooling: Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Inspec Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|-----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|-----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

D2906

Rev B

100

100

DOCUMENT CONTROL

DC

Document Control

Memo

0.00

Photocopy D209-669 bluefile & type labels per PPP D205-669-043 Chg 002 003 per GLN 12-591

100

110

Skidtubes

Skidtubes

Memo

0.00

- Inspect mat'l D2500-1-190 for damage

- Drill pilot holes using drill jig DT8149, DT8711-2 & DT8711-3 (Do not use cutting fluid)

- Open holes to 0.500" as per Dwg D2906 without cutting fluid

- Deburr and blow out all chips from

- Acid etch and Alodine tube per QSI 005 4.1

003 per GLN 12-591

> CF 12-6-11

SGP
PLC 12-06-11

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 84893***84893***

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NS2Start Date: 29/05/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|--------------|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | *NR1* |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | *NR2* |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|----------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120 *120* QC | QC3- Inspect Part Finish Memo | 0.00 | | | | 1 | SAD D-06-11 | | |
| Quality Control | | | | | | | | | |

130
130 Skidtubes

Memo 0.00

Skidtubes
-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting
Pick:Qty Part Number Description Batch
A/R Sikaflex-291 *M121409*Sikaflex expire date: *13-4-12*Start Time: *16:00* Date: *12-6-11*
Fin Time: *2:00* Date: *12-07-04*

pick:

Qty P/N description B/N
1 D2926-3 Web _____

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

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Item ID: D209-669-043

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Setup Start

NS1

Revision ID:

Item Name: Replacement Skidtube

Stop

NS2Start Date: 29/05/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|--------------|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | *NR1* |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | *NR2* |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|---------------------------|---|------|--|--|--|--|--|--|--|
| 170 | Large Fab | 0.00 | | | | | | | |
| *170* Skidtubes | Memo | 0.00 | | | | | | | |
| | -Drill holes for wearplates using DT8217 Open holes to 19/64", adjust stopper not to hit web. Deburr | | | | | | | | |
| | -Drill pilot holes for aft & fwd cap using DT8215 open holes to #6" Deburr | | | | | | | | |
| | -Drill pilot holes for Tow ring using DT8091-3 , open to .640" and Deburr | | | | | | | | |

| | | | | | | | | | |
|--------------------|---|------|--|--|--|--|--|--|--|
| 190 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *190* QC | Memo | 0.00 | | | | | | | |
| Quality Control | 5/21/07/05 | | | | | | | | |

DP 12-7-4

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | |
| | | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
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NOTE: Date & initial all entries

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Start

NS1

Revision ID:

Item Name: Replacement Skidtube

Stop

NS2Start Date: 29/05/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

Pressure Wash per QSI005 4.3

0.00

200

HandFinish

Hand Finishing

1 ✓ 6/12/12

210

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

210

Powdercoat

Powder Coating

Memo

10:00 00-
START TIME: 320 01-
OVEN TEMPERATURE:
FINISH TIME: 10:30m-f
12/07/05

220

QC3- Inspect Part Finish

0.00

220

QC

Quality Control

Memo

0.00

W ✓ M 11/07/05

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D209-669-043

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N900040100

Setup

Start

NS1

Revision ID:

Item Name: Replacement Skidtube

Stop

NS2Start Date: 29/05/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|--------------|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | *NR1* |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | *NR2* |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|----------------|--------|--------------|---------------|---------------|------------------|---------------------|
| 240 *240* QC | QC5- Inspect part completeness to step on W/O | 0.00 | <i>Calotra</i> | | | | | | |
| Quality Control | Memo Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024 | 0.00 | | | | | | | |
| 250 *250* Packaging Packaging | Packaging | 0.00 | | | | | | | <i>12/12/23</i> |
| | Memo Identify and pack for shipping as per PPPD209-669-043 Location: <i>PPD 84912</i> | 0.00 | | | | | | | |
| 260 *260* QC | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | <i>MUJ 12/10/23</i> |
| Quality Control | Memo | 0.00 | | | | | | | <i>MUJ 12/07/23</i> |

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 84893

84893
D209-669-043

Parent Item: D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: new IPP 08.02.13 LL, verified by: DD
IPP Rev:B remove DT # in seq140 DD 10.03.10 Verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|------------------|--|--------------|----|--|--|--|-----------------|----------------|-----------------|----|--|--|--|
| D4202-1 | | Manufactured | No | | | | Each | 81.0000 | | 19 | | | |
| *D4202-1* | | | | | | | | | | | | | |
| Spacer | | | | | | | | | | | | | |
| | | | | | | | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> | | | | |
| | | | | | | | B84763 | | | | | | |
| | | | | | | | LG | 5 | | | | | |
| | | | | | | | 77727 | 5 | | | | | |
| | | | | | | | LG002 | 76 | | | | | |
| | | | | | | | 78806 | 6 | | | | | |
| | | | | | | | 79810 | 70 | | | | | |

| | | | | | | | | | | | | | |
|--------------------------|--|--------------|----|--|--|--|-----------------|----------------|-----------------|---|---|--|--|
| D2500-1-190 | | Manufactured | No | | | | 110 | Each | 91.0000 | 1 | 1 | | |
| *D2500-1-190* | | | | | | | | | | | | | |
| Ext'n - 'I' Beam Tube 4" | | | | | | | | | | | | | |
| | | | | | | | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> | | | | |
| | | | | | | | HALL | 91 | | | | | |
| | | | | | | | 74777 | 14 | | | | | |
| | | | | | | | 80061 | 77 | | | | | |

| | | | | | | | | | | | | | |
|------------------|--|--------------|----|--|--|--|-----|------|--------|---|---|--|--|
| D2926-3 | | Manufactured | No | | | | 110 | Each | 0.0000 | 1 | 1 | | |
| *D2926-3* | | | | | | | | | | | | | |
| Web | | | | | | | | | | | | | |

| | | | | | | | | | | | | | |
|----------------|--|--------------|----|--|--|--|-----|------|---------|---|---|--|--|
| D2855 | | Manufactured | No | | | | 230 | Each | 21.0000 | 2 | 2 | | |
| *D2855* | | | | | | | | | | | | | |
| Cap | | | | | | | | | | | | | |

| | | | | | | | | | | | | |
|--|--|--|--|--|--|--|-----------------|----------------|-----------------|--|--|--|
| | | | | | | | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> | | | |
| | | | | | | | FP002 | 21 | | | | |
| | | | | | | | 65519 | 2 | | | | |
| | | | | | | | 73347 | 16 | | | | |
| | | | | | | | 75074 | 3 | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 84893

84893
D209-669-043

Parent Item: D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-5A

Purchased

No

230

Each

1,090.000

4

4

**

M u 1107105

AN3-5A?

Bolt

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST350 | 1090 | |
| 115371 | 46 | |
| 117423 | 124 | |
| 118626 | 31 | |
| 119355 | 200 | |
| 120187 | 500 | |
| 121185 | 189 | |

AN960JD10L

NAS1149D0332J Purchased

No

230

Each

0.0000

4

4

M111011 **

(x4) M u 1107105

AN960JD10L

Washer

ALS7-1032-130

Purchased

No

230

Each

2,136.000

44

44

**

M u 1107105

ALS7-1032-130

Insert

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST280 | 51 | |
| 117717 | 27 | |
| 118966 | 22 | |
| 119775 | 2 | |
| ST282 | 2085 | |
| 119530 | 73 | |
| 120181 | 12 | |
| 121444 | 2000 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Work Order ID: 84893

84893

Parent Item: D209-669-043

D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

230

Each

1,458.000

44

44

**

44 1207105

AN3C4A

BOLT

| Location | Loc Qty | Loc Code |
|---------------|---------|----------|
| ST350 | 1458 | |
| 120187 | 57 | |
| 120521 | 28 | |
| 120769 | 38 | |
| <u>121205</u> | 1000 | X44 |
| 121556 | 335 | |

AN960C10L

NAS1149C0332

R

Purchased

No

230

Each

0.0000

44

44

11122063 **

44 44 1207105

*AN960C10L * *

washer

D2594-3

Manufactured

No

230

Each

2,418.000

14

14

**

44 1207105

D2594-3

O-Ring, 205 Skidtube

| Location | Loc Qty | Loc Code |
|--------------|---------|----------|
| FP001 | 2418 | |
| 65518 | 41 | |
| 79496 | 984 | |
| 79573 | 50 | |
| <u>79755</u> | 1343 | V14 |

| W/O: | | WORK ORDER CHANGES | | | | | |
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84893
D209-669-043

Parent Item: D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured No

230

Each

311.0000

14

14

**

HL 12107105

D2594-1

Plug, 205 Skidtube

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP001 | 98 | |
| 73401 | 30 | |
| 74442 | 18 | |
| 79495 | 50 | |
| FP-A | 213 | |
| 73401 | 0 | |
| 78590 | 213 | |

D3564-9

Manufactured No

230

Each

22.0000

1

1

**

HL 12107105

D3564-9

Wearshoe

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FG | 4 | |
| 76950 | 4 | |
| FP001 | 18 | |
| 67590 | 4 | |
| 69943 | 1 | |
| 82255 | 13 | |

D3564-11

Manufactured No

230

Each

8.0000

1

1

**

HL 12107105

D3564-11

Wearshoe

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FG | 4 | |
| 77056 | 4 | |
| FP001 | 4 | |
| 80341 | 4 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

May-29-12 2:47:42 PM

Page 5

Work Order ID: 84893

84893

Parent Item: D209-669-043

D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

230

Each

13.0000

1

1

**

M 17/07/05

D3564-5

Wearshoe

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
|----------|---------|----------|

| | | |
|----|---|--|
| FG | 2 | |
|----|---|--|

| | | |
|-------|---|--|
| 34806 | 2 | |
|-------|---|--|

| | | |
|-------|----|--|
| FP001 | 11 | |
|-------|----|--|

| | | |
|-------|---|--|
| 77609 | 3 | |
|-------|---|--|

| | | |
|-------|---|--|
| 82254 | 8 | |
|-------|---|--|

D3566-1

Manufactured No

230

Each

31.0000

2

2

**

M 17/07/05

D3566-1

Gasket

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
|----------|---------|----------|

| | | |
|----|-----|--|
| FP | -22 | |
|----|-----|--|

| | | |
|-------|----|--|
| 81619 | 10 | |
|-------|----|--|

| | | |
|-------|----|--|
| FP002 | 53 | |
|-------|----|--|

| | | |
|-------|---|--|
| 68924 | 2 | |
|-------|---|--|

| | | |
|-------|---|--|
| 80919 | 3 | |
|-------|---|--|

| | | |
|-------|----|--|
| 83898 | 16 | |
|-------|----|--|

D3566-5

Manufactured No

230

Each

21.0000

1

1

**

M 17/07/05

D3566-5

Gasket

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
|----------|---------|----------|

| | | |
|----|----|--|
| FP | 12 | |
|----|----|--|

| | | |
|-------|----|--|
| 82275 | 12 | |
|-------|----|--|

| | | |
|-------|---|--|
| FP002 | 9 | |
|-------|---|--|

| | | |
|-------|---|--|
| 80374 | 3 | |
|-------|---|--|

| | | |
|-------|---|--|
| 82274 | 6 | |
|-------|---|--|

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

| QTY | QTY | Part Number | Description |
|------|------|---|-----------------------------|
| -041 | -043 | D2906-041 | SKIDTUBE ASSEMBLY |
| X | X | D2906-043 | SKIDTUBE ASSEMBLY |
| 1 | 1 | D2500-1-190 | EXTRUSION |
| 22 | 19 | D2579 | CROSS BOLT SPACER |
| 12 | 14 | D2594-1 | PLUG |
| 12 | 14 | D2594-3 | O-RING |
| 2 | 2 | D2855 | AFT CAP |
| 1 | 1 | D2926-1 | WEB |
| 1 | 1 | D2926-3 | WEB |
| 1 | 1 | D3564-9 | WEARSHOE (REPLACES D2577-1) |
| 1 | 1 | D3564-11 | WEARSHOE (REPLACES D2577-3) |
| 1 | 1 | D3564-5 | WEARSHOE (REPLACES D2577-5) |
| 1 | 2 | D3564-15 | WEARSHOE |
| 1 | 2 | D3566-1 | GASKET |
| 1 | 1 | D3566-5 | GASKET |
| 1 | 1 | D3566-15 | GASKET |
| 50 | 44 | ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130 | INSERT |
| | | AN3C4A AN3-5A | BOLT |
| 50 | 44 | AN960C10L | BOLT |
| 50 | 44 | AN960C10L | WASHER |
| 4 | 4 | AN960UD10L | WASHER |



GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = .190 INCHES.
- 3) INSERT D2926-1/3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/281 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 6) USE DART DRILL TEMPLATE DT2906-04-111 (DT2906-04-043T1 (D2906-043) TO LOCATE AND DRILL Ø.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/281.
- 7) WELDING TO BE DONE PER DART QSI 004.
- 8) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2926-1/-3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 9) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).
- 10) ALL DIMENSIONS ARE IN INCHES.

RELEASED
07.04.04 *dh*

| REV. | DESCRIPTION | BY | DATE |
|------------|-------------|--|----------|
| DESIGN | 97 | DART AEROSPACE LTD | |
| DRAWN | CB | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>dh</i> | DRAWING NO. | |
| MFG. APPR. | <i>dh</i> | PG 2 C7: REMOVE AFT Ø.640 HOLE FROM -041; PG 3 C3: CORRECTED -043 CAP P/N; PG 3 D7: 38 PLACES WAS 44 PLACES; | |
| APPROVED | <i>dh</i> | TITLE | |
| DE APPR. | <i>dh</i> | AH-1 (209) SKIDTUBE ASSEMBLY | |
| DATE | 07.08.21 | CP | 04.06.22 |
| | | CB | 07.08.21 |
| | | REV. B | |
| | | SHEET 1 OF 3 | |
| | | SCALE | |
| | | NTS | |

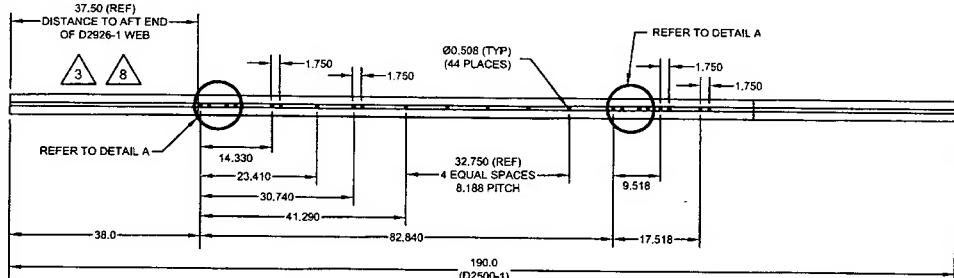
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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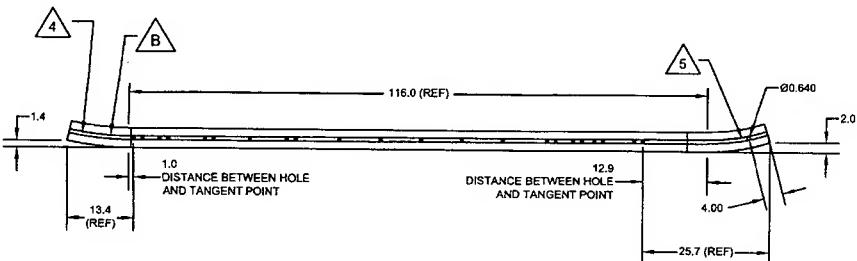
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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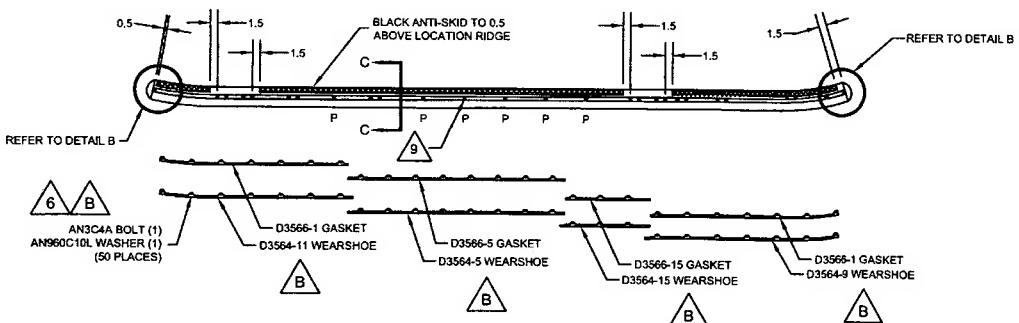
NOTE: Date & initial all entries



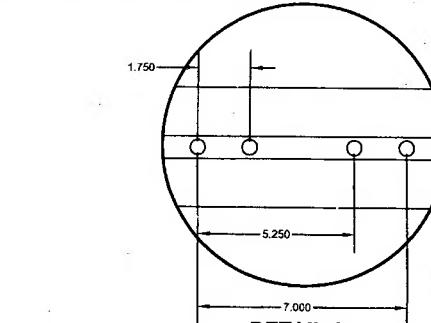
D2906-1 DRILLING DETAIL



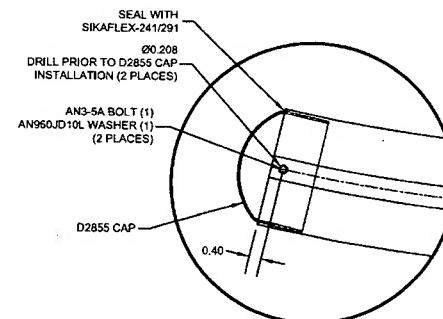
D2906-041 BENDING AND CUTTING DETAIL



D2906-041 ASSEMBLY DETAIL

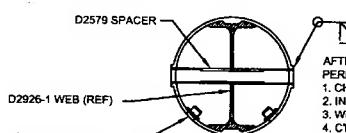


DETAIL A



DETAIL B

RELEASER
07.09.04



SECTION C-C

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (22 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. CBORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

| | | | | |
|------------|----------------------|------------------------------|--------------|--|
| DESIGN | <i>90</i> | DART AEROSPACE LTD | | |
| DRAWN | <i>CB</i> | HAWKESBURY, ONTARIO, CANADA | | |
| CHECKED | <i>PH</i> | DRAWING NO. | REV. B | |
| MFG. APPR. | <i>91</i> | D2906 | SHEET 2 OF 3 | |
| APPROVED | <i>HP</i> | TITLE | SCALE | |
| DE APPR. | <i>HP</i> | AH-1 (209) SKIDTUBE ASSEMBLY | | |
| DATE | 07.08.21 | 1:24 | | |

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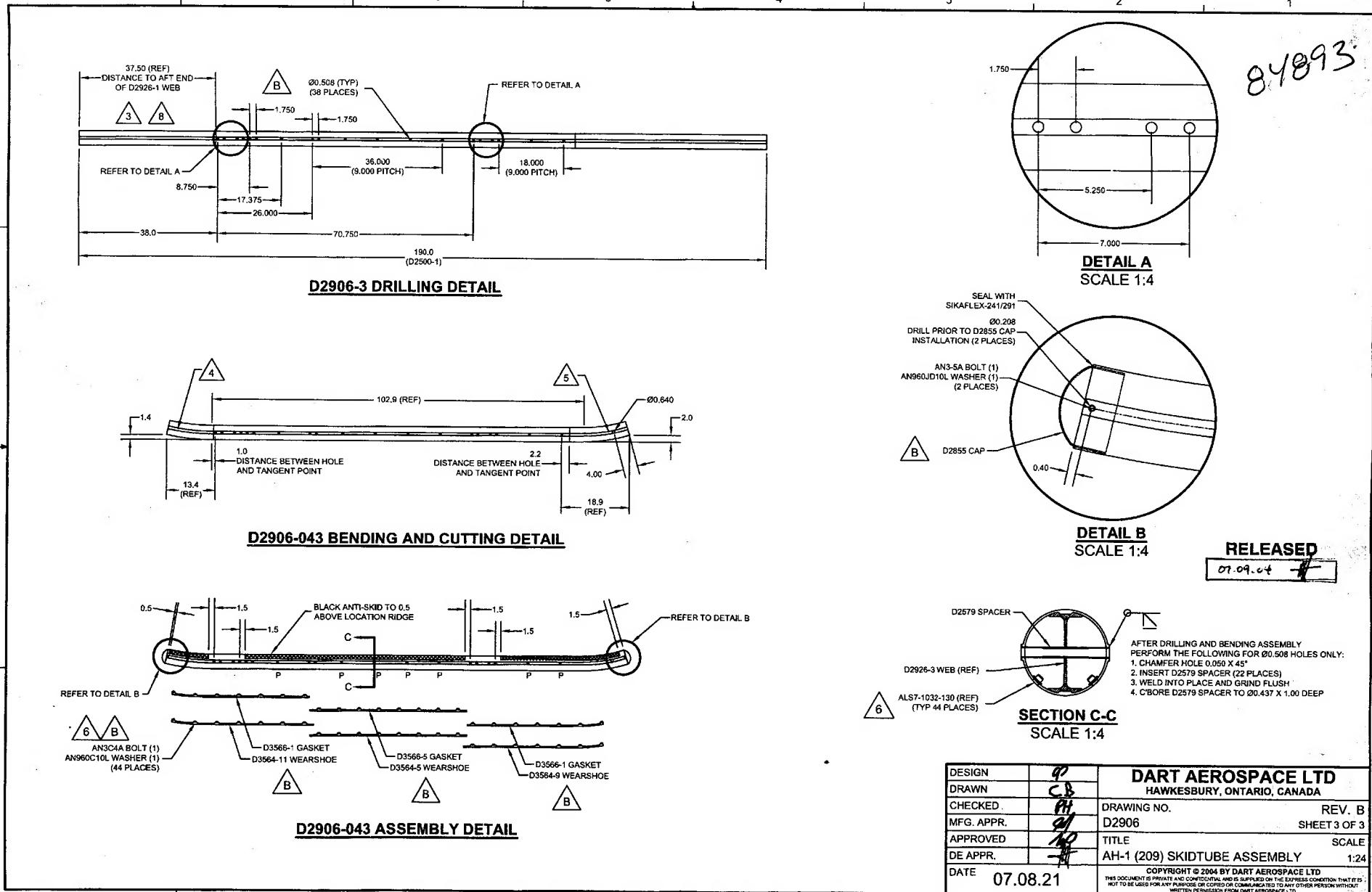
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NOTE: Date & initial all entries



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